

Work Order ID 85968

85968

Page 1

Item ID: D2344

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Deck Plate, 350

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2344

Rev F

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg

prog rev: F

dwg rev: F

2-deburr as required

10 0 Jm 12-6-23

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 Jm 12-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85968

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June-19-12 11:56:54 AM

Item ID: D2344

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Revision ID:

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Item Name: Litter Deck Plate, 350

Start Date: 19/06/2012 Start Qty: 10.00

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

QC Memo

0.00

Quality Control

10 12/06/24

130

0.00

130

Small Fab

Small Fab Memo

0.00

Small Fab 1-Deburr sharp edges 2-Countersink holes per Dwg D2344

10 12/06/24

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC Memo

0.00

Quality Control

5/12/06/24

(40)

Dart Aerospace Ltd

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Start Date: 19/06/2012 Start Qty: 10.00

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Required Date: 03/07/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

10 ~~10~~ 12-6-27

155

QC7-Inspect Chemical Conversion Coat

0.00

155

QC

Memo

0.00

Quality Control

10X ~~10X~~ M-F 12/07/03

160

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

8-15

8-45

10X ~~10X~~ M-F 12/07/03

M 12/27/09

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June-19-12 11:56:55 AM

Item ID: D2344

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N900040100

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Revision ID:

Item Name: Litter Deck Plate, 350

Stop ***NS2***

Start Date: 19/06/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: <i>85224</i>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

10 6 12-7-3

102 80 2-7-3

12/7/4

MF 12-07-03

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NOTE: Date & initial all entries

Picklist Print

June-19-12 11:56:58 AM

Page 1

Work Order ID: 85968

85968

Parent Item: D2344

D2344

Parent Item Name: Litter Deck Plate, 350

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:D00.06.26Removed P/O for powder coatEC
IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	268.9700	0.745	7.842105			

M2024T3S 063

2024-T3 .063 sheet

**

Jun-26-23

Location

Loc Qty

Loc Code

MAT022

268.97

119916

73.27

121197

195.7

121197

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DART AEROSPACE LTD		Work Order:	85968
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.224"	✓		✓	mmoi
5.598	+/-0.010	5.604"	✓		✓	mmoi
4.869	+/-0.010	4.876"	✓		✓	mmoi
3.889	+/-0.010	3.896"	✓		✓	mmoi
3.096	+/-0.010	3.100"	✓		✓	mmoi
2.891	+/-0.010	2.894	✓		✓	mmoi
16.973	+/-0.010	16.973"	✓		mt	HB01
0.450	+/-0.010	0.454"	✓		✓	mmoi
4.423	+/-0.010	4.423"	✓		✓	mmoi
4.723	+/-0.010	4.721"	✓		✓	mmoi
1.202	+/-0.010	1.198"	✓		✓	mmoi
5.869	+/-0.010	5.870"	✓		✓	mmoi
4.654	+/-0.010	4.660"	✓		✓	mmoi
Ø0.656	+0.005/-0.000	0.656"	✓		✓	mmoi
1.888	+/-0.010	1.891"	✓		✓	mmoi
2.285	+/-0.010	2.286"	✓		✓	mmoi
2.683	+/-0.010	2.687	✓		✓	mmoi
Ø0.171	+0.005/-0.000	0.172"	✓		✓	mmoi
3.491	+/-0.010	3.495"	✓		✓	mmoi
Ø0.191	+0.005/-0.000	0.192"	✓		✓	mmoi
3.123	+/-0.010	3.130"	✓		✓	mmoi
1.975	+/-0.010	1.982"	✓		✓	mmoi
Ø0.128	+0.005/-0.001	0.129"	✓		✓	mmoi

Measured by:	JM	Audited by:	M/W	Prototype Approval:	N/A
Date:	12-6-23	Date:	12-6-24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	AF

Dart Aerospace Ltd

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